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(54) **BICYCLE CRANK ASSEMBLY**

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CPC ..... **B62M 9/105** (2013.01); **B62M 3/00** (2013.01); **Y10T 74/2165** (2015.01)

(58) **Field of Classification Search**  
USPC ..... 74/594.1, 594.2  
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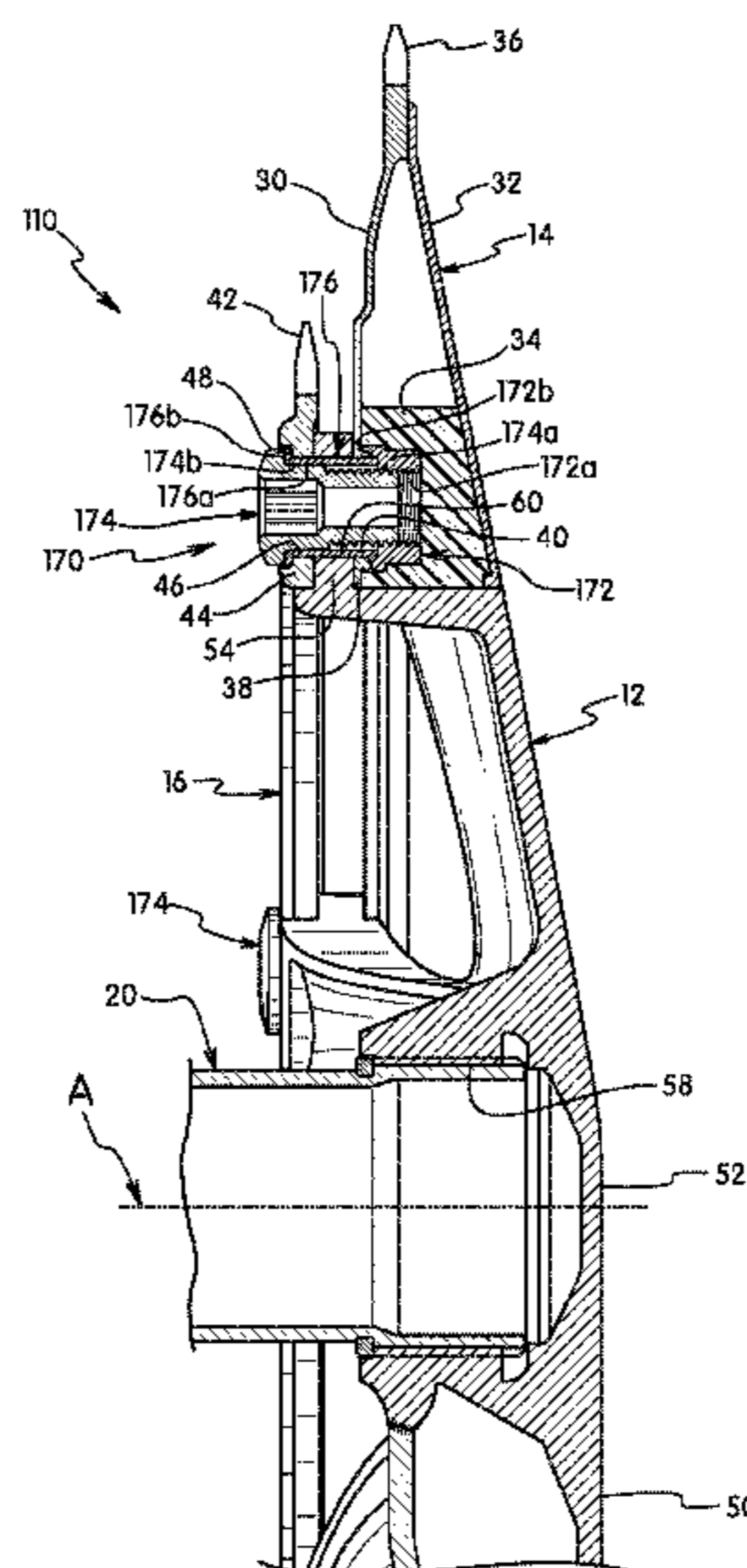
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(57) **ABSTRACT**

A bicycle crank assembly is provided with a first sprocket, a second sprocket, a crank arm, a sprocket fixing structure and an alignment tube. The first sprocket includes a plurality of first teeth and at least one first mounting portion having a first mounting opening. The second sprocket includes a plurality of second teeth and at least one second mounting portion having a second mounting opening. The crank arm includes at least one sprocket attachment portion having a third mounting opening. The sprocket fixing structure secures the first and second sprockets to the crank arm via the first, second and third mounting openings. The alignment tube extends through at least two of the first, second and third mounting openings.

**14 Claims, 11 Drawing Sheets**



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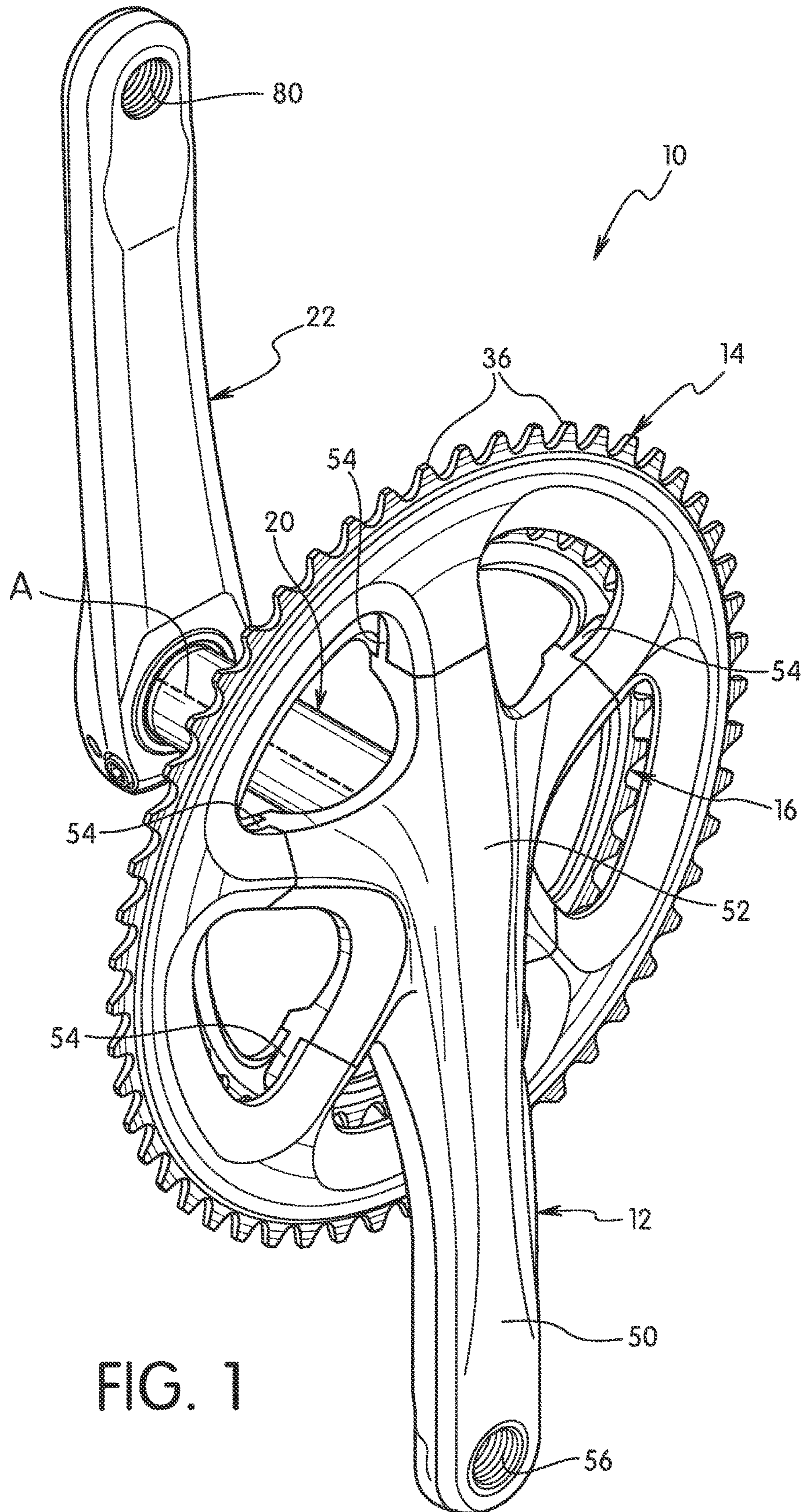


FIG. 1

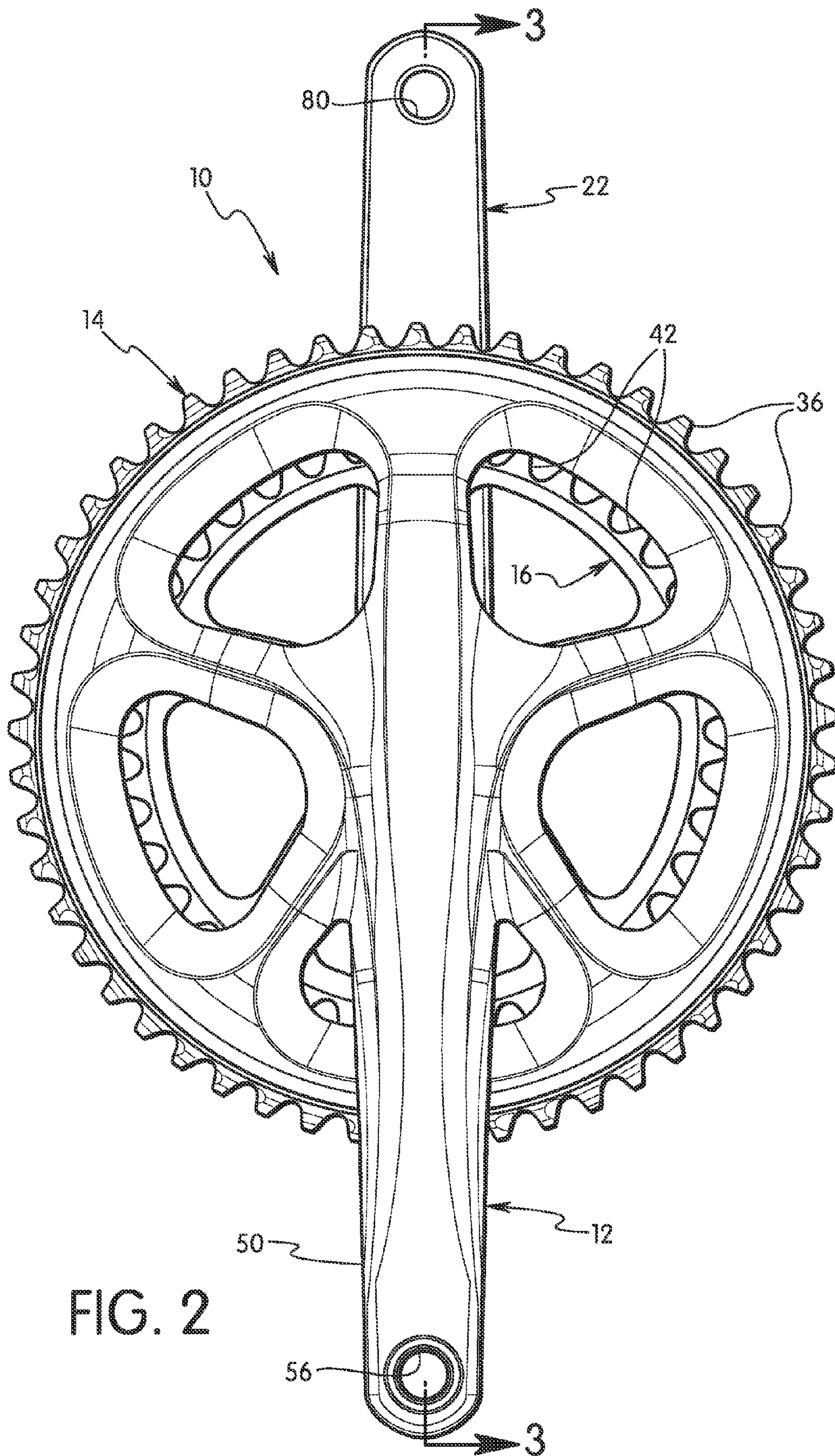


FIG. 2

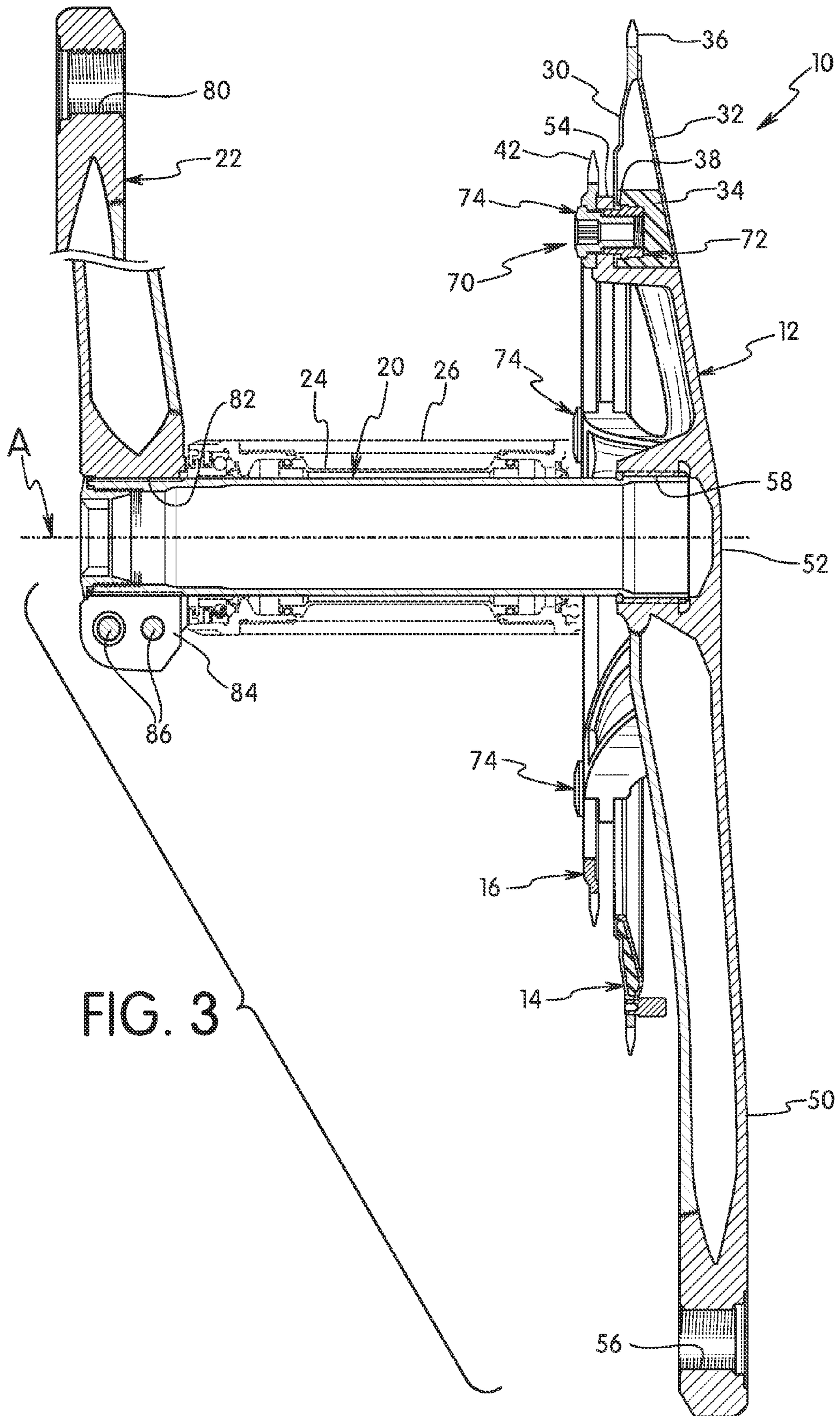


FIG. 3









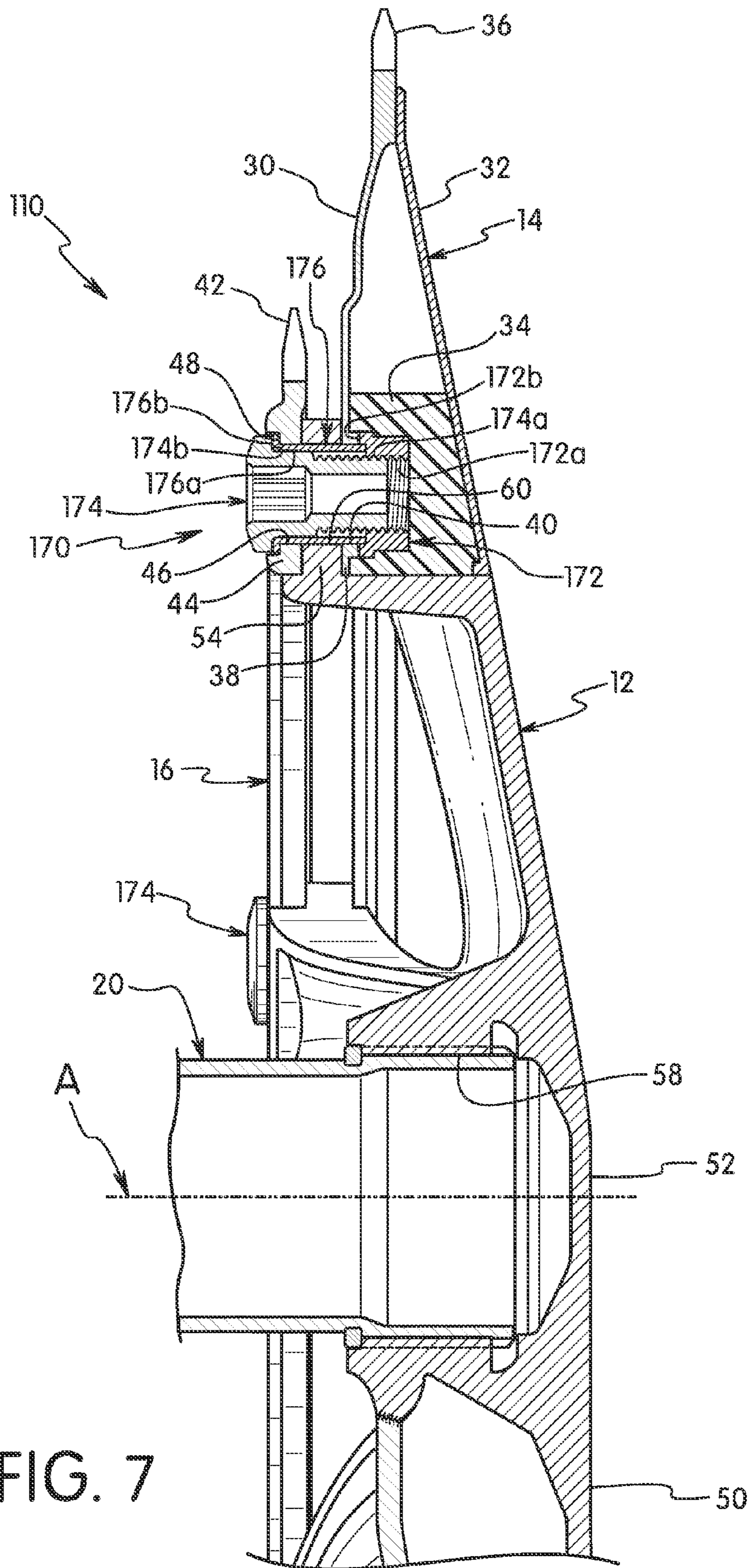


FIG. 7

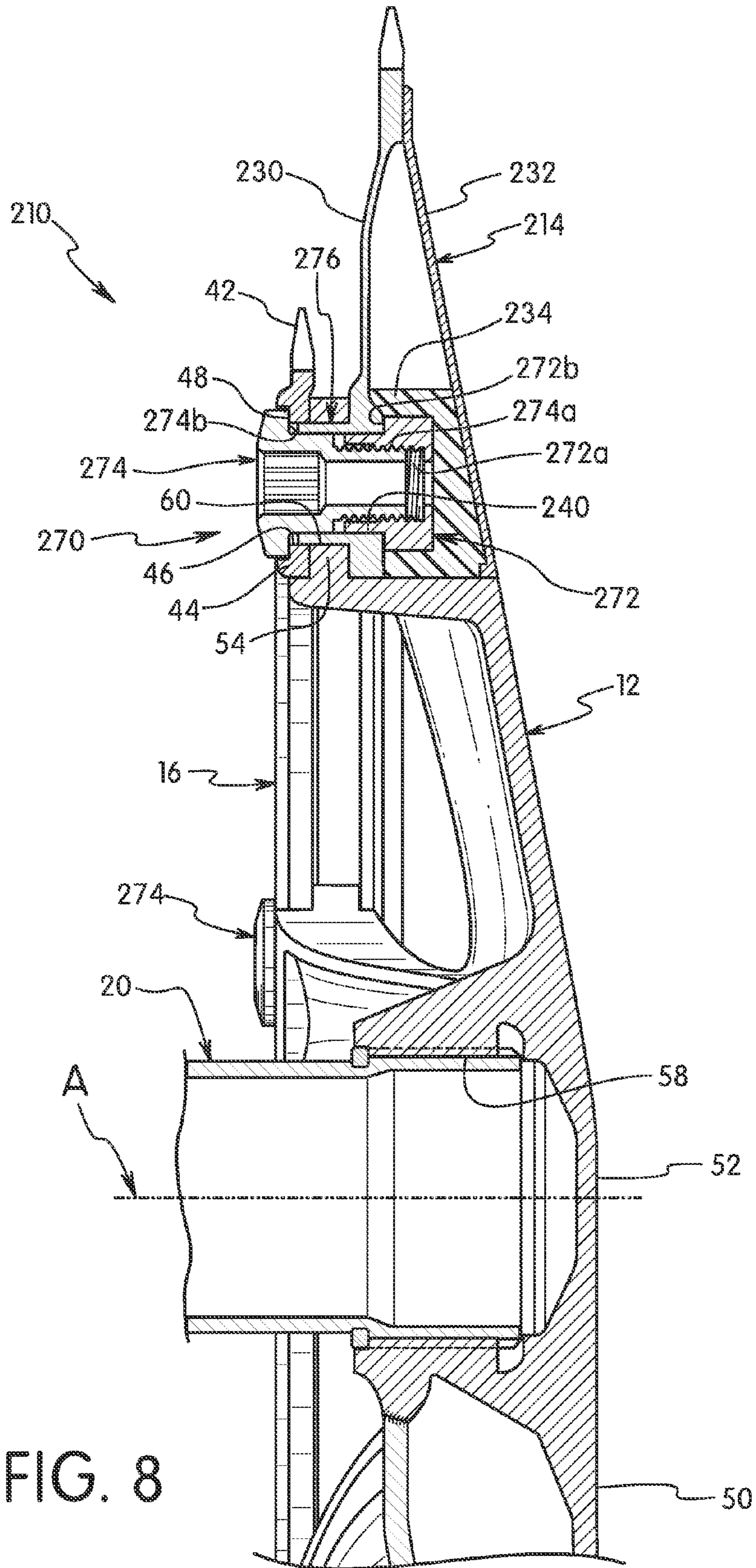


FIG. 8



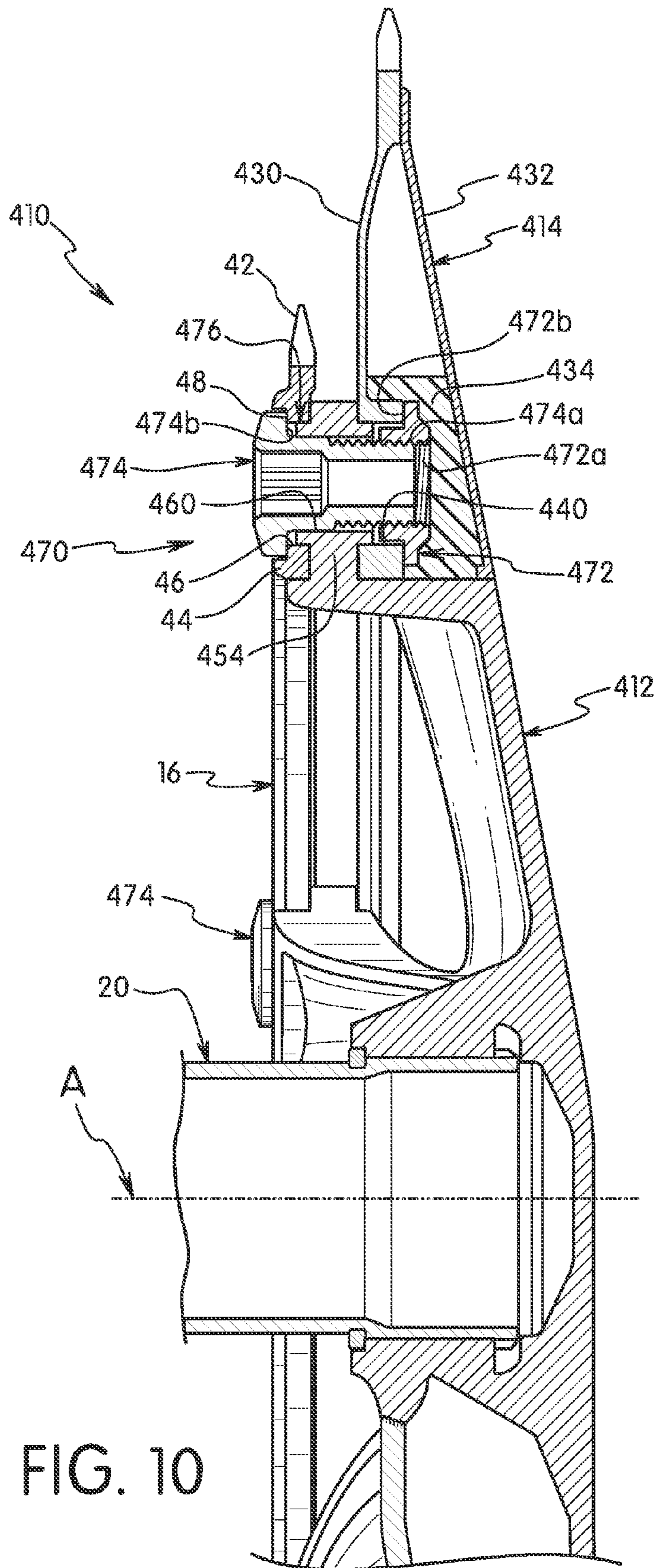
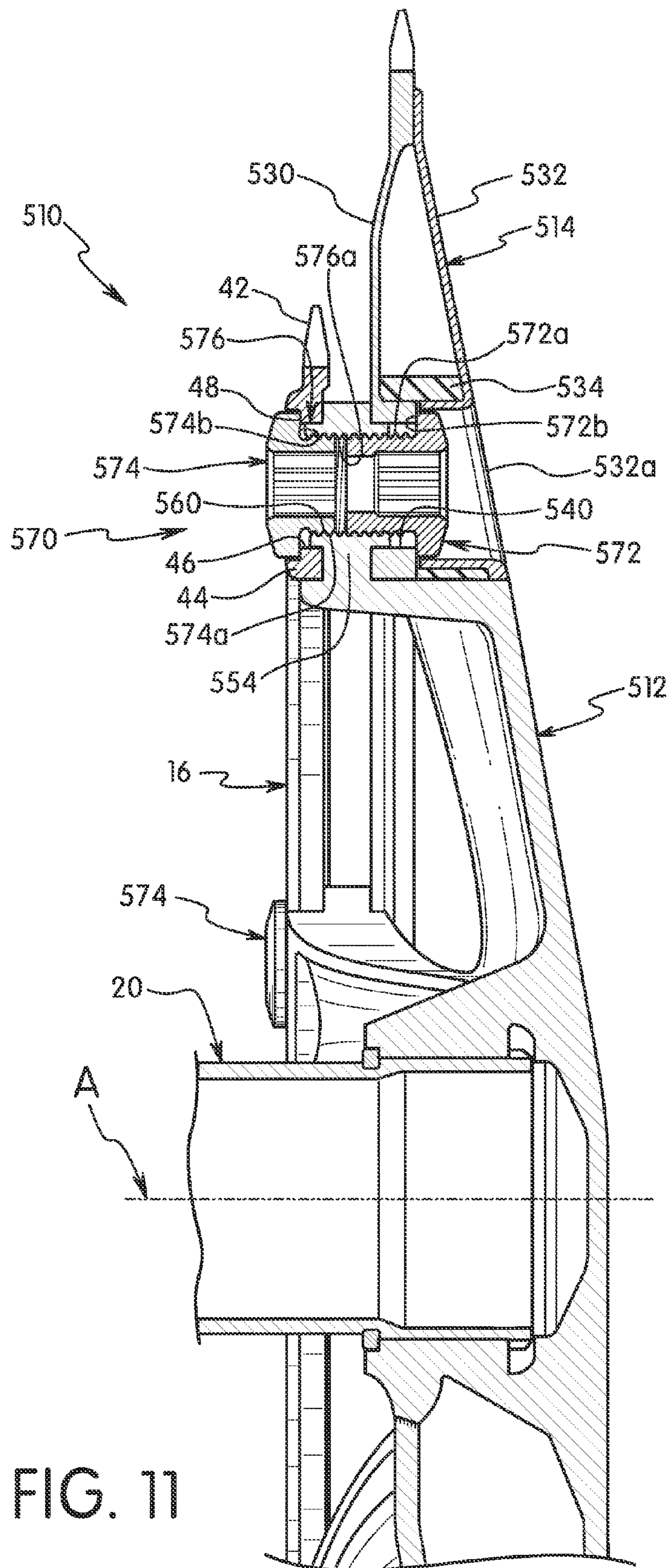


FIG. 10



## 1

## BICYCLE CRANK ASSEMBLY

## BACKGROUND

## Field of the Invention

This invention generally relates to a bicycle crank assembly. More specifically, the present invention relates to a bicycle crank assembly having an attachment structure for attaching a pair of sprockets to a crank arm.

## Background Information

Generally speaking, a conventional bicycle has a diamond-shaped bicycle frame with a pair of wheels rotatably mounted to the frame and a drive train coupled to the frame for driving the rear wheel. The drive train typically has a bicycle crank assembly mounted to the cylindrical or tubular hanger part of the bicycle frame. The bicycle crank assembly drives a chain that rotates a sprocket mounted to the rear wheel. The bicycle crank assembly usually includes a crank axle that is mounted in a freely rotatable-manner to a hanger tube of the bicycle frame. A crank arm is fastened to each end of the crank axle. The right crank arm typically has one or more sprockets attached thereto for driving the chain. As used herein, the terms "right" and "left" are often used to describe bicycle components on the assumption that the bicycle is viewed from the rear. The sprockets are sometimes attached the right crank arm by a plurality of fixing bolts and a plurality of fixing nuts as shown in U.S. Pat. No. 7,258,041 (assigned to Shimano Inc.). In this conventional bicycle crank assembly, the sprockets are, in an assembled state, directly disposed on a fixing bolt or a fixing nut which is detachable from the sprockets and the right crank arm. The center axes of the fixing bolts can easily become inclined with respect to the center axes of the fixing nuts during attachment of the sprockets to the crank arm, as a result it can be difficult and/or time consuming to accurately position sprockets on the crank arm.

## SUMMARY

One aspect presented in this disclosure is to provide a bicycle crank assembly that improves positioning accuracy between two sprockets mounted to a crank arm during assembly.

In view of the state of the known technology, a bicycle crank assembly is presented in this disclosure that comprises a first sprocket, a second sprocket, a crank arm, a sprocket fixing structure and an alignment tube. The first sprocket includes a plurality of first teeth and at least one first mounting portion having a first mounting opening. The second sprocket includes a plurality of second teeth and at least one second mounting portion having a second mounting opening. The crank arm includes at least one sprocket attachment portion having a third mounting opening. The sprocket fixing structure secures the first and second sprockets to the crank arm via the first, second and third mounting openings. The alignment tube extends through at least two of the first, second and third mounting openings.

These and other objects, features, aspects and advantages of the bicycle crank assembly presented in this disclosure will become apparent to those skilled in the art from the following detailed description, which, taken in conjunction with the annexed drawings, discloses several embodiments.

## BRIEF DESCRIPTION OF THE DRAWINGS

Referring now to the attached drawings which form a part of this original disclosure:

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FIG. 1 is an assembled perspective view of a bicycle crank assembly in accordance with a first embodiment;

FIG. 2 is an outside elevational view of the bicycle crank assembly illustrated in FIG. 1;

FIG. 3 is a transverse cross sectional view of the bicycle crank assembly illustrated in FIGS. 1 and 2;

FIG. 4 is an inside elevational view of the bicycle crank assembly illustrated in FIGS. 1 to 3, but with the left crank arm removed;

FIG. 5 is an exploded perspective view of the bicycle crank assembly illustrated in FIGS. 1 to 4;

FIG. 6 is an enlarged transverse cross sectional view of one of the sprocket attachment portions of the bicycle crank axle assembly illustrated in FIGS. 1 to 5;

FIG. 7 is an enlarged transverse cross sectional view of a sprocket attachment portion of a bicycle crank axle assembly in accordance with a second embodiment;

FIG. 8 is an enlarged transverse cross sectional view of a sprocket attachment portion of a bicycle crank axle assembly in accordance with a third embodiment;

FIG. 9 is an enlarged transverse cross sectional view of a sprocket attachment portion of a bicycle crank axle assembly in accordance with a fourth embodiment;

FIG. 10 is an enlarged transverse cross sectional view of a sprocket attachment portion of a bicycle crank axle assembly in accordance with a fifth embodiment; and

FIG. 11 is an enlarged transverse cross sectional view of a sprocket attachment portion of a bicycle crank axle assembly in accordance with a sixth embodiment.

## DETAILED DESCRIPTION OF EMBODIMENTS

Selected embodiments will now be explained with reference to the drawings. It will be apparent to those skilled in the art from this disclosure that the following descriptions of the embodiments are provided for illustration only and not for the purpose of limiting the invention as defined by the appended claims and their equivalents.

Referring to FIGS. 1 to 6, a bicycle crank axle assembly 10 is illustrated in accordance with a first embodiment. The bicycle crank axle assembly 10 includes a right crank arm 12 having a first sprocket 14 and a second sprocket 16. The first and second sprockets 14 and 16 are fixedly secured to the right crank arm 12 in a releasable and reinstallable manner as explained below. The bicycle crank axle assembly 10 further includes a crank axle 20 and a left crank arm 22. The right crank arm 12 is fixed to a first (right) end of the crank axle 20 in a conventional manner (e.g., crimping, locking ring, adhesive, etc.). The left crank arm 22 is fixed to a second (left) end of the crank axle 20 in a releasable and reinstallable manner (e.g., clamping or other suitable arrangement).

As seen in FIG. 3, the bicycle crank axle assembly 10 is rotatably supported by a bottom bracket 24 in a hanger tube 26 for rotation about a center rotational axis A of the bottom bracket 24. The bottom bracket 24 is a conventional structure. Thus, the bottom bracket 24 will not be discussed or illustrated in detail herein. Rather, the following description will primarily focus on the attachment of the first and second sprockets 14 and 16 to the right crank arm 12.

First, the first and second sprockets 14 and 16 will be discussed in more detail. In the first illustrated embodiment, the second sprocket 16 is a solid metal chain ring, while the first sprocket 14 is a composite chain ring having an inner shell or cover 30, an outer shell or cover 32 and a filler part 34. The inner and outer shells 30 and 32 preferably made of a metallic material or any other suitable rigid material such

as a fiber-reinforced resin, preferably a carbon fiber-reinforced resin. For example, the inner and outer shells **30** and **32** can be formed of a suitable metallic material such as a stainless steel, an aluminum alloy, a magnesium alloy, a titanium alloy, etc. The inner and outer shells **30** and **32** are fixedly coupled together by bonding (e.g., adhesive, welding, brazing, etc.) to define an interior space that is partly filled with the filler part **34** that is preferably made of a plastic resin material or any other suitable filler material. The filler part **34** can be considered a resin part when at least partial made of a resin material. The filler part **34** can include reinforcing fibers as needed and/or desired.

The first sprocket **14** includes a plurality of first teeth **36** and a plurality of first mounting portions **38** with each having a first mounting opening **40**. The first teeth **36** are integrally formed with the inner shell **30** as a one-piece, unitary member. The first mounting portions **38** are mainly formed by the inner shell **30** and portions of the filler part **34** that surround the first mounting openings **40**. In the first illustrated embodiment, the first sprocket **14** has five of the first mounting portions **38** with identical configurations, except that the shape of the exterior side of one of the first mounting portions **38** is contoured differently from the remaining four of the first mounting portions **38** such that the outer shell **32** flushly mates with the right crank arm **12**. The structures of the inner shell **30** forming the first mounting portions **38** are identical. However, it will be apparent to those skilled in the art from this disclosure that each of the first mounting portions **38** can be substantially different from each other, and that the first sprocket **14** can have fewer or more of the first mounting portions **38**, as needed and/or desired.

Similarly, as best seen in FIGS. **5** and **6**, the second sprocket **16** includes a plurality of second teeth **42** and a plurality of second mounting portions **44** with each of the second mounting portions **44** having a second mounting opening **46**. The second sprocket **16** has a recessed portion **48** (FIG. **6**) around the second mounting opening **46**. The second sprocket **16** is a one-piece, unitary member that is preferably formed of a suitable metallic material such as a stainless steel, an aluminum alloy, a magnesium alloy, a titanium alloy, etc. In the first illustrated embodiment, the second sprocket **16** has five of the second mounting portions **44** with identical configurations. However, it will be apparent to those skilled in the art from this disclosure that the second mounting portions **44** do not need to be identical, and that the second sprocket **16** can have fewer or more of the second mounting portions **44**, as needed and/or desired.

Now, as seen in FIGS. **3** to **5**, the right crank arm **12** will be discussed in more detail. The right crank arm **12** includes a gear crank portion **50**, a crank axle attachment portion **52** and a plurality of sprocket attachment portions **54**. The right crank arm **12** is illustrated as being formed with a two-piece construction from a light metal such as an aluminum alloy, a magnesium alloy, a titanium alloy, or other suitable light metal. In particular, a metallic cover member is fixedly attached (i.e., bonded) to a metallic body member that is a one-piece, unitary part. As a result, the gear crank portion **50** has an interior space to reduce the weight of the right crank arm **12**. This interior space can be empty or filled with a resin material as needed and/or desired. However, the right crank arm **12** is not limited to this construction. The right crank arm **12** can be formed of a single piece or of several pieces of various materials.

As seen in FIGS. **3** and **5**, the gear crank portion **50** has tip or free end portion with a pedal attachment hole **56** that is threaded for threadedly attaching a pedal (not shown). The

crank axle attachment portion **52** has a crank axle attachment hole **58** that has a plurality of splines for engaging the crank axle **20** to prevent rotation therebetween as seen in FIG. **3**. Alternatively, the right crank arm **12** may be designed to be removably fastened to the crank axle **20** as needed and/or desired. In the first illustrated embodiment, each of the sprocket attachment portions **54** has a third mounting opening **60** as best seen in FIG. **5**. The crank axle attachment portion **52** and the sprocket attachment portions **54** form a substantially starfish-shaped member that functions as a spider arm for the gear crank portion **50**.

In order to secure the first and second sprockets **14** and **16** to the right crank arm **12**, the bicycle crank assembly **10** further includes a plurality of sprocket fixing structures **70**. The sprocket fixing structure **70** secures the first and second sprockets **14** and **16** to the crank arm **12** via the first, second and third mounting openings **40**, **46** and **60**, respectively. In the first illustrated embodiment, each of the sprocket fixing structures **70** includes a fixing nut **72** having an internal thread **72a** and a fixing bolt **74** having an external thread **74a**. The external thread **74a** of the fixing bolt **74** is threaded into the internal thread **72a** of the fixing nut **72** to secure the first and second sprockets **14** and **16** to the right crank arm **12**. The fixing nut **72** includes an abutment part **72b** that contacts one of the first and second sprockets **14** and **16**, while the fixing bolt **74** includes an abutment part **74b** that contacts the other of the first and second sprockets **14** and **16**. The abutment part **74b** of the fixing bolt **74** is preferably disposed in the recessed portion **48** of the second sprocket **16** in the assembled state.

In the first illustrated embodiment, each of the fixing nuts **72** are embedded in the filler (resin) part **34** of the first sprocket **14** so that the fixing nuts **72** align with the first mounting openings **40**. The fixing nuts **72** are preferably formed of a suitable metallic material such as a chrome molybdenum steel, an aluminum alloy, a magnesium alloy, a titanium alloy, etc. In order to accurately position the first and second sprockets **14** and **16** to the right crank arm **12**, the bicycle crank assembly **10** further includes a plurality of alignment tubes **76**. In the first illustrated embodiment, the alignment tubes **76** are integrally formed with the fixing nuts **72** and extend axially from the abutment part **72b**. Thus, the alignment tubes **76** extend through corresponding ones of the first, second and third mounting openings **40**, **46** and **60**. The right crank arm **12** and the first and second sprockets **14** and **16** are aligned by the alignment tubes **76**. Because the alignment tubes **76** are integrally formed with the fixing nuts **72**, which are non-detachably, i.e. firmly, fixed to the first sprocket **14**, it is possible to achieve accurate positioning of the first and second sprockets **14** and **16** and the right crank arm **12** even if the center axes of the fixing bolts **74** become inclined with respect to the center axes of the fixing nuts **72** during attachment of the first and second sprockets **14** and **16** to the right crank arm **12**. The alignment tubes **76** are cylindrical with an outer diameter that is dimensioned to substantially match the inner diameters of the mounting openings **40**, **46** and **60**. However, the alignment tubes **76** are not limited to a cylindrical tube. The alignment tubes **76** can have other shapes that snugly engage the mounting openings **40**, **46** and **60**, which can be cylindrical bores or other suitable shapes. In any event, the alignment tubes **76** are dimensioned relative to the mounting openings **40**, **46** and **60** such that the first and second sprockets **14** and **16** are accurately position relative to the right crank arm **12** and the center rotational axis A.

While in the first illustrated embodiment, each of the sprocket fixing structures **70** are identical with the alignment

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tubes 76 integrally formed with the fixing nuts 72, it will be apparent to those skilled in the art from this disclosure that each of the sprocket fixing structures 70 can have a different construction, if needed and/or desired. For example, only one of the sprocket fixing structures 70 can be configured with the alignment tube 76 integrally formed with the fixing nut 72 as seen in FIG. 6, while the remaining sprocket fixing structures 70 can be configured with conventional sprocket fixing structures. Alternatively, for example, some of the sprocket fixing structures 70 can have the configuration as seen in FIG. 6, while other sprocket fixing structures can be either conventional or constructed according to one of the later embodiments.

In the first illustrated embodiment, the crank axle 20 is a hollow pipe-shaped member that is highly rigid. For example, the crank axle 20 is made of a metallic material as chrome molybdenum steel. Preferably, the crank axle 20 defines a longitudinal axis that substantially coincides with the rotational center axis A of the bottom bracket 24. As shown in FIG. 3, the crank arms 12 and 22 are fixed to opposite end portions of the crank axle 20 and extend in opposite directions. The left crank arm 22 is removably fastened to a first or left end portion of the crank axle 20, while the right crank arm 12 is preferably fixed to a second or right end portion of the crank axle 20 so that the right crank arm 12 is integrally coupled to the crank axle 20 through a splined-connection. In particular, as shown in FIG. 3, a first or left end portion of the crank axle 20 includes a female or internal thread 20a and a plurality of external splines or serrations 20b.

As seen in FIGS. 1 to 3, the left crank arm 22 has a tip or free end portion with a pedal attachment hole 80 that is threaded for threadedly attaching a pedal (not shown). As seen in FIG. 3, the left crank arm 22 has a connecting hole 82 with a radial slit 84. The connecting hole 82 of the left crank arm 22 is mounted on the crank axle 20. The left crank arm 22 is strongly fixed on the crank axle 20 by tightening up two mounting bolts 86 that are located on the bottom of the crank axle 20 as seen in FIG. 3. Thus, the width of the slit 84 is narrowed by tightening the mounting bolts 86 that extend across the slit 84 to strongly fix the left crank arm 22 on the crank axle 20. These two mounting bolts 86 are, for example, hexagon socket head bolts, and their heads are preferably inserted from different directions with respect to the slit 84.

Referring now to FIG. 7, a sprocket attachment portion of a bicycle crank axle assembly 110 will now be explained in accordance with a second embodiment. In view of the similarity between the first and second embodiments, the parts of the second embodiment that are identical to the parts of the first embodiment will be given the same reference numerals as the parts of the first embodiment. Moreover, the descriptions of the parts of the second embodiment that are identical to the parts of the first embodiment may be omitted for the sake of brevity.

Here, the crank axle assembly 110 is provided with a plurality of sprocket fixing structures 170 (only one shown) for securing the first and second sprockets 14 and 16 to the right crank arm 12. Each of the fixing structures 170 includes a fixing nut 172 and a fixing bolt 174. However, a separate alignment tube 176 is provided for receiving each of the sprocket fixing structures 170. Thus, basically, the only difference between the first and second embodiments is that the alignment tubes 176 are not integrally formed with the fixing nut 172 in the crank axle assembly 110 of the second embodiment. In other words, each of the alignment

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tubes 176 is a bushing that extends through the first, second and third mounting openings 40, 46 and 60, respectively.

Similar to the first embodiment, the fixing nut 172 is embedded in the filler (resin) part 34 of the first sprocket 14. Also similar to the first embodiment, the fixing bolt 174 has an external thread 174a that threadedly engages an internal thread 172a of the fixing nut 172 to secure the first and second sprockets 14 and 16 to the right crank arm 12. The fixing nut 172 also includes an abutment part 172b that contacts the first sprocket 14, while the fixing bolt 174 includes an abutment part 174b that contacts the second sprocket 16. The abutment part 174b of the fixing bolt 174 is preferably disposed in the recessed portion 48 of the second sprocket 16 in the assembled state.

In the second embodiment, preferably, each of the alignment tubes or bushings 176 (only one shown) includes a tubular portion 176a and a flange portion 176b. The tubular portion 176a extends through the first, second and third mounting openings 40, 46 and 60, respectively. The flange portion 176b extends in a radial direction from the tubular portion 176a. The flange portion 176b is pinched between the second sprocket 14 and the abutment part 174b of the fixing bolt 174. In the second embodiment, the alignment tubes 176 are bushings that are separate members from the fixing nuts 172 and the fixing bolt 174. Therefore, even if the center axes of the fixing bolts 174 become inclined with respect to the center axes of the fixing nuts 172 during attachment of the first and second sprockets 14 and 16 to the right crank arm 12, such inclination of the fixing bolts 174 less affects positioning of the first and second sprockets 14 and 16 and the right crank arm 12.

Referring now to FIG. 8, a sprocket attachment portion of a bicycle crank axle assembly 210 will now be explained in accordance a third embodiment. In view of the similarity between the first and third embodiments, the parts of the third embodiment that are identical to the parts of the first embodiment will be given the same reference numerals as the parts of the first embodiment. Moreover, the descriptions of the parts of the third embodiment that are identical to the parts of the first embodiment may be omitted for the sake of brevity.

Here in this third embodiment, the crank axle assembly 210 is provided with a modified first sprocket 214 and a plurality of sprocket fixing structures 270 (only one shown) for securing the first and second sprockets 214 and 16 to the right crank arm 12. Each of the fixing structures 270 includes a fixing nut 272 and a fixing bolt 274. However, in this third embodiment, an alignment tube 276 is integrally formed with the first sprocket 214 at each of the first mounting openings 240 for receiving each of the sprocket fixing structures 270. The first sprocket 214 is identical to the first sprocket 14, discussed above, except that the alignment tubes 276 (only one shown) have been integrally formed with an inner shell 230 of the first sprocket 214 at each of the first mounting openings 240 as a one-piece, unitary member, and that the wall thickness of the inner shell 230 of the first sprocket 214 has been increased at each of the first mounting openings 240. In other words, each of the alignment tubes 276 only extends through the second and third mounting openings 46 and 60, respectively, in this third embodiment.

Similar to the first embodiment, the fixing nut 272 is embedded in a filler (resin) part 234 of the first sprocket 214. Also similar to the first embodiment, the fixing bolt 274 has an external thread 274a that threadedly engages an internal thread 272a of the fixing nut 272 to secure the first and second sprockets 214 and 16 to the right crank arm 12. The



fixing nut **272** also includes an abutment part **272b** that contacts the first sprocket **214**, while the fixing bolt **274** includes an abutment part **274b** that contacts the second sprocket **16**. The abutment part **274b** of the fixing bolt **274** is preferably disposed in the recessed portion **48** of the second sprocket **16** in the assembled state. Because the alignment tubes **276** are integrally formed with the first sprocket **214**, it is possible to achieve accurate positioning of the first and second sprockets **214** and **16** and the right crank arm **12** even if the center axes of the fixing bolts **274** become inclined with respect to the center axes of the fixing nuts **272** during attachment of the first and second sprockets **214** and **16** to the right crank arm **12**.

Referring now to FIG. **9**, a sprocket attachment portion of a bicycle crank axle assembly **310** will now be explained in accordance with a fourth embodiment. In view of the similarity between the first and fourth embodiments, the parts of the fourth embodiment that are identical to the parts of the first embodiment will be given the same reference numerals as the parts of the first embodiment. Moreover, the descriptions of the parts of the fourth embodiment that are identical to the parts of the first embodiment may be omitted for the sake of brevity.

Here in this fourth embodiment, the crank axle assembly **310** is provided with a modified first sprocket **314**, a modified second sprocket **316** and a plurality of sprocket fixing structures **370** (only one shown) for securing the first and second sprockets **314** and **316** to the right crank arm **12**. Each of the fixing structures **370** includes a fixing nut **372** and a fixing bolt **374**. However, in this fourth embodiment, an alignment tube **376** is integrally formed with the second sprocket **316** at each of the second mounting openings **346** for receiving each of the sprocket fixing structures **370**. The first sprocket **314** is identical to the first sprocket **14**, discussed above, except that the wall thickness of an inner shell **330** of the first sprocket **314** has been increased at each of the first mounting openings **340**. The second sprocket **316** is identical to the second sprocket **16**, discussed above, except that the alignment tubes **376** have been integrally formed with the second sprocket **316** as a one-piece, unitary member. In other words, each of the alignment tubes **376** only extends through the first and third mounting openings **340** and **360**, respectively, in this fourth embodiment.

Similar to the first embodiment, the fixing nut **372** is embedded in a filler (resin) part **334** of the first sprocket **314**. Also similar to the first embodiment, the fixing bolt **374** has an external thread **374a** that threadedly engages an internal thread **372a** of the fixing nut **372** to secure the first and second sprockets **314** and **316** to the right crank arm **12**. The fixing nut **372** also includes an abutment part **372b** that contacts the first sprocket **314**, while the fixing bolt **374** includes an abutment part **374b** that contacts the second sprocket **316**. The abutment part **374b** of the fixing bolt **374** is preferably disposed in a recessed portion **348** of the sprocket mounting portion **344** of the second sprocket **316** in the assembled state. Because the alignment tubes **376** are integrally formed with the second sprocket **316**, it is possible to achieve accurate positioning of the first and second sprockets **314** and **316** and the right crank arm **12** even if the center axes of the fixing bolts **374** become inclined with respect to the center axes of the fixing nuts **372** during attachment of the first and second sprockets **314** and **316** to the right crank arm **12**.

Referring now to FIG. **10**, a sprocket attachment portion of a bicycle crank axle assembly **410** will now be explained in accordance with a fifth embodiment. In view of the similarity between the first and fifth embodiments, the parts of the fifth

embodiment that are identical to the parts of the first embodiment will be given the same reference numerals as the parts of the first embodiment. Moreover, the descriptions of the parts of the fifth embodiment that are identical to the parts of the first embodiment may be omitted for the sake of brevity.

Here in this fifth embodiment, the crank axle assembly **410** is provided with a modified right crank arm **412**, a modified first sprocket **414**, and a plurality of sprocket fixing structures **470** (only one shown) for securing the first and second sprockets **414** and **16** to the right crank arm **412**. Each of the fixing structures **470** includes a fixing nut **472** and a fixing bolt **474**. However, in this fifth embodiment, an alignment tube **476** is integrally formed with the crank arm **412** on each sprocket attachment portion **454** at each of the third mounting openings **460** for receiving each of the sprocket fixing structures **470**. The first sprocket **414** is identical to the first sprocket **14**, discussed above, except that the wall thickness of an inner shell **430** of the first sprocket **414** has been increased at each of the first mounting openings **440**. The right crank arm **412** is identical to the right crank arm **12**, discussed above, except that the alignment tubes **476** (only one shown) are integrally formed with the crank arm **412** at each of the third mounting openings **460**. The alignment tubes **476** extend in opposite axial directions with respect to the center axes of the third mounting openings **460** from the sprocket attachment portions **454** (only one shown). In other words, each of the alignment tubes **476** only extends through the first and second mounting openings **440** and **46**, respectively, in this fifth embodiment.

Similar to the first embodiment, the fixing nut **472** is embedded in a filler (resin) part **434** of the first sprocket **414**. Also similar to the first embodiment, the fixing bolt **474** has an external thread **474a** that threadedly engages an internal thread **472a** of the fixing nut **472** to secure the first and second sprockets **414** and **16** to the right crank arm **412**. The fixing nut **472** also includes an abutment part **472b** that contacts the first sprocket **414**, while the fixing bolt **474** includes an abutment part **474b** that contacts the second sprocket **16**. The abutment part **474b** of the fixing bolt **474** is preferably disposed in the recessed portion **48** of the second sprocket **16** in the assembled state. Because the alignment tubes **476** are integrally formed with the crank arm **412**, it is possible to achieve accurate positioning of the first and second sprockets **414** and **16** and the crank arm **412** even if the center axes of the fixing bolts **474** become inclined with respect to the center axes of the fixing nuts **472** during attachment of the first and second sprockets **414** and **16** to the right crank arm **412**.

Referring now to FIG. **11**, a sprocket attachment portion of a bicycle crank axle assembly **510** will now be explained in accordance with a sixth embodiment. In view of the similarity between the first and sixth embodiments, the parts of the sixth embodiment that are identical to the parts of the first embodiment will be given the same reference numerals as the parts of the first embodiment. Moreover, the descriptions of the parts of the sixth embodiment that are identical to the parts of the first embodiment may be omitted for the sake of brevity.

Here in this sixth embodiment, the crank axle assembly **510** is provided with a modified right crank arm **512**, a modified first sprocket **514**, and a plurality of sprocket fixing structures **570** (only one shown) for securing the first and second sprockets **514** and **16** to the right crank arm **512**. In this sixth embodiment, each of the fixing structures **570** includes a first fixing bolt **572** with an external thread **572a**

and a second fixing bolt **574** with an external thread **574a**. Thus, the fixing nut of the prior embodiments has been replaced with the first fixing bolt **572** in this sixth embodiment. Also, in this sixth embodiment, an alignment tube **576** is integrally formed with the crank arm **512** on each sprocket attachment portion **554** at each of the third mounting openings **560** for receiving each of the sprocket fixing structures **570**. Each of the alignment tubes **576** (only one shown) of the crank arm **512** has an internal thread **576a** formed along the third mounting openings **560** so that the external threads **572a** and **574a** of the first and second fixing bolts **572** and **574** are threaded into the internal thread **576a** of the alignment tubes **576** of the crank arm **512**.

The first sprocket **514** is identical to the first sprocket **14**, discussed above, except that the wall thickness of an inner shell **530** of the first sprocket **514** has been increased at each of the first mounting openings **540** and an outer shell **532** of the first sprocket **514** has been provided with an opening **532a** at each of the sprocket fixing structures **570** for accessing the in the first fixing bolts **572**. The right crank arm **512** is identical to the right crank arm **12**, discussed above, except that the alignment tubes **576** (only one shown) are integrally formed with the crank arm **512** at each of the third mounting openings **560** and the alignment tubes **576** (only one shown) are each provided with the internal thread **576a**. The alignment tubes **576** extend in opposite axial directions with respect to the center axes of the third mounting openings **560** from the sprocket attachment portions **554** (only one shown) of the crank arm **512**. In other words, each of the alignment tubes **576** only extends through the first and second mounting openings **540** and **46**, respectively, in this sixth embodiment.

In this sixth embodiment, each of the first fixing bolts **572** also includes an abutment part **572b** that contacts the first sprocket **514**, while each of the second fixing bolts **574** includes an abutment part **574b** that contacts the second sprocket **16**. The abutment part **574b** of the fixing bolt **574** is preferably disposed in the recessed portion **48** of the second sprocket **16** in the assembled state. Because the alignment tubes **576** are integrally formed with the crank arm **512**, it is possible to achieve accurate positioning of the first and second sprockets **514** and **16** and the crank arm **512** even if the center axes of the first and second fixing bolts **572** and **574** become inclined with respect to the center axes of the internal threads **576a** during attachment of the first and second sprockets **514** and **16** to the crank arm **512**.

In understanding the scope of the present invention, the term “comprising” and its derivatives, as used herein, are intended to be open ended terms that specify the presence of the stated features, elements, components, groups, integers, and/or steps, but do not exclude the presence of other unstated features, elements, components, groups, integers and/or steps. The foregoing also applies to words having similar meanings such as the terms, “including”, “having” and their derivatives. Also, the terms “part,” “section,” “portion,” “member” or “element” when used in the singular can have the dual meaning of a single part or a plurality of parts. As used herein to describe the above embodiment(s), the following directional terms “forward”, “rearward”, “above”, “downward”, “vertical”, “horizontal”, “below” and “transverse” as well as any other similar directional terms refer to those directions of a bicycle equipped with the bicycle crank assembly. Accordingly, these terms, as utilized to describe the bicycle crank assembly should be interpreted relative to a bicycle equipped with the bicycle crank assembly as used in the normal riding position on a flat horizontal surface. Finally, terms of degree such as “substantially”,

“about” and “approximately” as used herein mean a reasonable amount of deviation of the modified term such that the end result is not significantly changed.

While only selected embodiments have been chosen to illustrate the present invention, it will be apparent to those skilled in the art from this disclosure that various changes and modifications can be made herein without departing from the scope of the invention as defined in the appended claims. For example, the size, shape, location or orientation of the various components can be changed as needed and/or desired. Components that are shown directly connected or contacting each other can have intermediate structures disposed between them. The functions of one element can be performed by two, and vice versa. The structures and functions of one embodiment can be adopted in another embodiment. It is not necessary for all advantages to be present in a particular embodiment at the same time. Every feature which is unique from the prior art, alone or in combination with other features, also should be considered a separate description of further inventions by the applicant, including the structural and/or functional concepts embodied by such feature(s). Thus, the foregoing descriptions of the embodiments according to the present invention are provided for illustration only, and not for the purpose of limiting the invention as defined by the appended claims and their equivalents.

What is claimed is:

1. A bicycle crank assembly comprising:
  - a first sprocket including a plurality of first teeth and at least one first mounting portion having a first mounting opening;
  - a second sprocket including a plurality of second teeth and at least one second mounting portion having a second mounting opening;
  - a crank arm including at least one sprocket attachment portion having a third mounting opening;
  - a sprocket fixing structure securing the first and second sprockets to the crank arm via the first, second and third mounting openings, the sprocket fixing structure including a fixing nut embedded in a resin part of the first sprocket, the fixing nut having an internal thread and a fixing bolt having an external thread, the external thread of the fixing bolt being threaded into the internal thread of the fixing nut; and
  - an alignment tube extending through at least two of the first, second and third mounting openings, the alignment tube being non-detachably maintained in a fixed relationship with one of the first sprocket, the second sprocket and the crank arm.
2. The bicycle crank assembly according to claim 1, wherein
  - the alignment tube is a bushing that is a separate member from the sprocket fixing structure, and
  - the bushing extends through the first, second and third mounting openings.
3. The bicycle crank assembly according to claim 2, wherein
  - the bushing includes a tubular portion that extends through the first, second and third mounting openings and a flange portion that extends in a radial direction from the tubular portion, the flange portion being pinched between one of the first and second sprockets and one of the fixing bolt and the fixing nut.
4. The bicycle crank assembly according to claim 1, wherein

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the alignment tube is integrally formed with the first sprocket and extends through the second and third mounting openings.

5. The bicycle crank assembly according to claim 1, wherein

the alignment tube is integrally formed with the second sprocket and extends through the first and third mounting openings.

6. The bicycle crank assembly according to claim 5, wherein

the fixing nut includes an abutment part first and second sprockets and the fixing bolt includes an abutment part that contacts the other of the first and second sprockets.

7. The bicycle crank assembly according to claim 1, wherein

the alignment tube is integrally formed with the crank arm and extends through the first and second mounting openings.

8. The bicycle crank assembly according to claim 7, wherein

the fixing nut includes an abutment part that contacts one of the first and second sprockets and the fixing bolt includes an abutment part that contacts the other of the first and second sprockets.

9. The bicycle crank assembly according to claim 1, wherein

the fixing nut includes an abutment part that contacts one of the first and second sprockets and the fixing bolt includes an abutment part that contacts the other of the first and second sprockets.

10. The bicycle crank assembly according to claim 9, wherein

at least one of the first and second sprockets has a recessed portion around at least one of the first and second mounting openings so that the abutment part of one of the fixing bolt and the fixing nut is disposed in the recessed portion upon assembled state.

11. The bicycle crank assembly according to claim 1, wherein

the resin part includes reinforcing fibers.

12. A bicycle crank assembly comprising:

a first sprocket including a plurality of first teeth and at least one first mounting portion having a first mounting opening;

a second sprocket including a plurality of second teeth and at least one second mounting portion having a second mounting opening;

a crank arm including at least one sprocket attachment portion having a third mounting opening;

**12**

a sprocket fixing structure securing the first and second sprockets to the crank arm via the first, second and third mounting openings, the sprocket fixing structure including a fixing nut embedded in a resin part of the first sprocket, the fixing nut having an internal thread and a fixing bolt having an external thread, the external thread of the fixing bolt being threaded into the internal thread of the fixing nut; and

an alignment tube extending through at least two of the first, second and third mounting openings, the alignment tube being non-detachably maintained in a fixed relationship with one of the first sprocket, the second sprocket and the crank arm, and

the alignment tube being integrally formed with the fixing nut and extending through the first, second and third mounting openings.

13. The bicycle crank assembly according to claim 12, wherein

one of the first and second sprockets includes an inner shell and an outer shell, and the resin part is disposed between the inner shell and the outer shell.

14. A bicycle crank assembly comprising:

a first sprocket including a plurality of first teeth and at least one first mounting portion having a first mounting opening;

a second sprocket including a plurality of second teeth and at least one second mounting portion having a second mounting opening;

a crank arm including at least one sprocket attachment portion having a third mounting opening;

a sprocket fixing structure securing the first and second sprockets to the crank arm via the first, second and third mounting openings, the sprocket fixing structure including a fixing nut having an internal thread and a fixing bolt having an external thread, the external thread of the fixing bolt being threaded into the internal thread of the fixing nut, the fixing nut having a thread that is only accessible from a bicycle frame facing side of the crank assembly such that the fixing bolt is installed from the bicycle frame facing side of the crank assembly; and

an alignment tube extending through at least two of the first, second and third mounting openings, the alignment tube being non-detachably maintained in a fixed relationship with one of the first sprocket, the second sprocket and the crank arm.

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